

Work Order ID 68967

Tuesday, April 26, 2011 2:22:12 PM



Page 1

Item ID: D3200-3

Accept



Setup Start



Revision ID:

Item Name: Door Wedge

Stop



Start Date: 4/26/2011 Start Qty: 24.00

Required Date: 4/29/2011 Req'd Qty: 24.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3200

Rev A

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jcaspa Bandsaw

Cut blank: 1.000 X 1.970"

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine D3200-3 as per Folio FA337 and Dwg D3200-2-Deburr

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC rec'd
Quality Control

Memo

0.00

rec'd + inspect ~~as per~~ part transit damage
attached C of C to WIO

11/06/09 25

Issue P10: 14260

Machine as per Dwg D3200 REV.A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Door Wedge

Start Date: 4/26/2011 Start Qty: 24.00

Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 24.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 040

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

COCA
725

11/6/23 (20)

11/6/27

MF
11-06-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

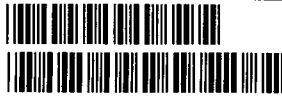
Tuesday, April 26, 2011 2:22:22 PM

Page 1

Work Order ID: 68967

Parent Item: D3200-3

Parent Item Name: Door Wedge





Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			100	sf	183.0000	0.015	0.378947			
UHMW 1" Black													

Location

Loc Qty

Loc Code

MAT018

183

116554

2

117321

181

117738

.5 SF # 11/06/09

D3200-3P

Pu 11/6/22 ps

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

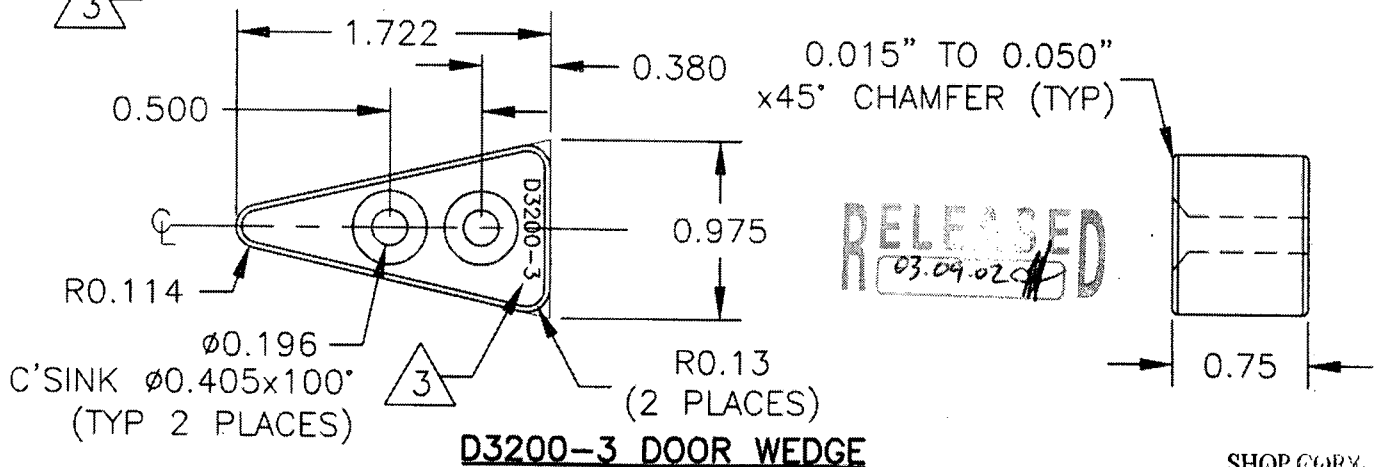
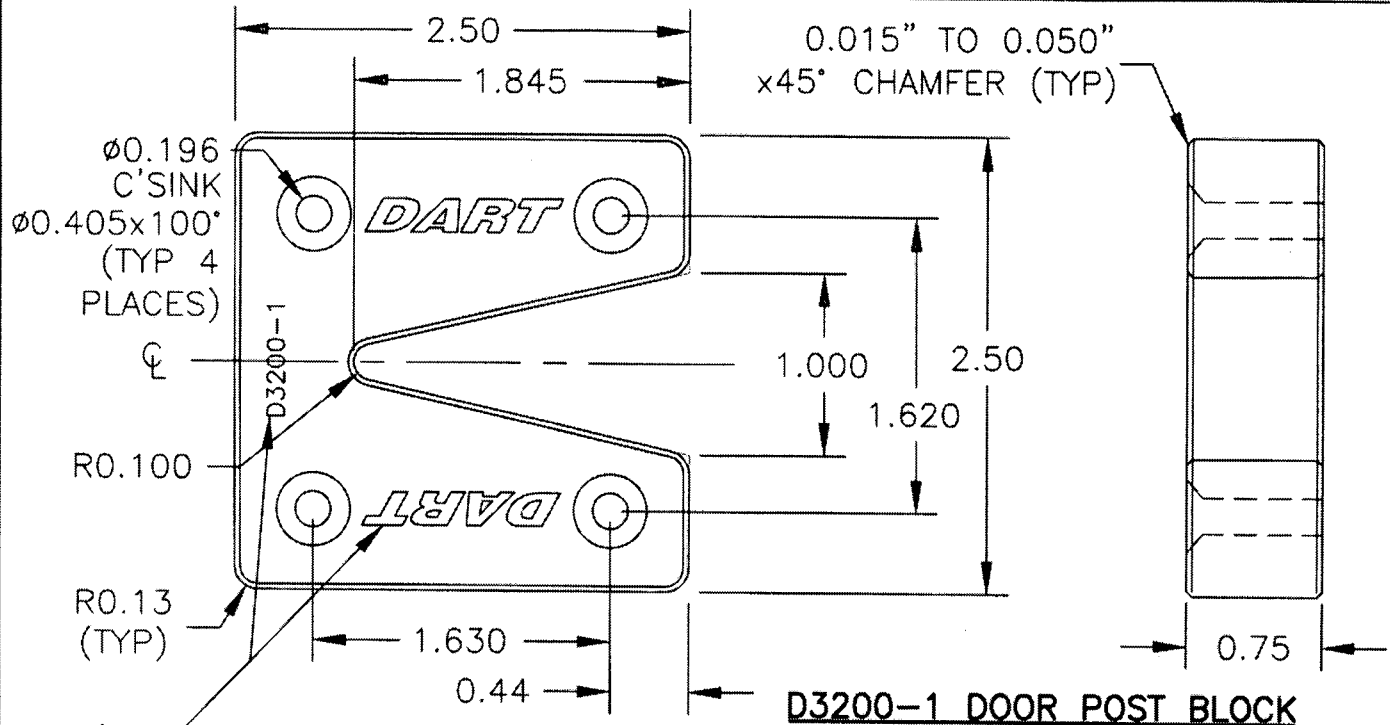
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DESIGN	DRAFT	DRAWN BY	DRAFT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓	APPROVED	✓	DRAWING NO.	REV. A
DATE				D3200	SHEET 1 OF 1
03.08.06				TITLE	SCALE
A				DOOR WEDGE	1:1
03.08.06				NEW ISSUE	



D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68967

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14260

Purchase Order Date 6/9/2011

PO Print Date 6/9/2011

Page Number 1 of 6

Order From :

VC-DAN003

DAN'S PRECISION TOOL
2560 DEVINE ROAD
VARS ONTARIO, K0A3H0

VARS, ON K0A3H0
CAN

FAKED
FOLIO

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613-835-3097	Requisition Nbr	
Vendor Fax	613-835-3760	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3200-1P	Door Wedge	6/24/2011 Yes	25.00 Each	FedEx PI collect	\$17.2000	\$430.00
		Special Inst:	MACHINE AS PER DWG D3200 REV. A B68969				
2	D3200-3P	Door Post Block	6/24/2011 Yes	25.00 Each	FedEx PI collect	\$10.5000	\$262.50
		Special Inst:	MACHINE AS PER DWG D3200 REV. A B68967				
4	D3414-3P	Lug Assembly	6/24/2011 Yes	40.00 Each	FedEx PI collect	\$14.8000	\$592.00
		Special Inst:	MACHINE AS PER DWG D3414 REV. C B70412				

6/9/2011

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: ~~DART~~ AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 22-Jun-11

Purchase Order : PO14260

Packing Slip : 10517

Part Number : D3200-3revA

Quantity : 25

86106/25

Per: _____

For Dan's Precision Tools Inc.

DAN'S PRECISION TOOLS INC.

Customer: DART AEROSPACE LTD.

P.O.: PO14260

W/O:

Part #: D3200-3 rev A

Door Post Block

Qty: 25

1 of 1